



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3886-1

Job Sheet 192890



Part No: D3886-1

Job Qty: 20 pcs

Part Name: Lug

60 pcs



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 5/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	5/8/19	5/8/19	0.00	1.17	Bandsaw - 1		J.C.C.
110	HAAS 4 Axis - B4B	20 pcs	5/8/19	5/8/19	0.13	9.62	HAAS - 1 - B4B		J.C.C. 19-05-27
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
115	Purchasing	20 pcs	5/8/19	5/8/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
120	Packaging 2-1 - Receive - B4B	20 pcs	5/8/19	5/8/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		C2
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		



Container No: S184256



Part: D3886-1

Job No: 192890

Serial No/Batch: S184256

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/27/19

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130 QC 8	20 pcs	5/8/19	0.00 0.00	Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 8 - 12	On 19/05/27
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Packaging 3-1 - Stock - B4B	20 pcs	5/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA 20 pcs 5/8/19 0.00 0.00				QC 21 - SA - 21	MAY 28 2019 DAS 70 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - BAND SAW Cut blanks: 2.50" x 0.500" x 2.250" long
 Descriptions: 110 - HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA812 and Dwg D3886 Identify as D3886-1 Dwg Rev
B Folio Rev 24
 115 - (Purchasing)
 120 - (Receive & Inspect for Damage & Mat'l Certs)
 130 - (QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____) LOCATION: WA001-5
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B0.500X2.500	304 Bar .500 X 2.50	3.8800 ft (.194 ea)	100-Bandsaw - 1	5173512

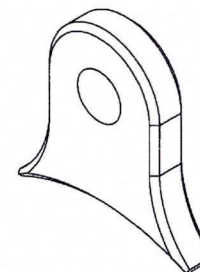
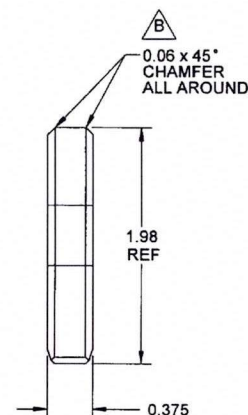
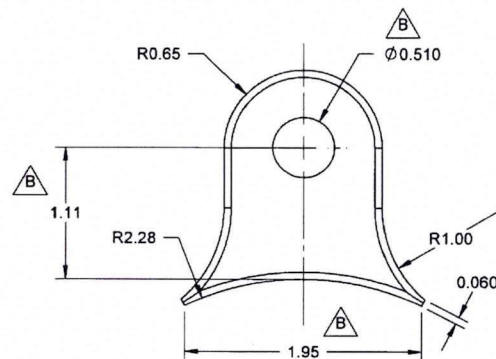
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304B0.500X2.500	4	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug	0.650Inches ± 0.030	0.680 0.620	Radius	
2	Lug	1.110Inches ± 0.030	1.140 1.080		
3	Lug	1.950Inches ± 0.030	1.980 1.920		
4	Lug	0.060Inches ± 0.010	0.070 0.050		
5	Lug	0.510Inches + 0.008 - 0.001	0.518 0.509	Diameter	
6	Lug	0.060Inches ± 0.030	0.090 0.030		
7	Lug	45.000Degrees ± 0.500	45.500 44.500	angle	
8	Lug	0.375Inches ± 0.010	0.385 0.365		

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D3886-1 LUG (B)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197840
ML5
19-4-05

RELEASED
[Signature]

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.30	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					